



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200  
Fax 613 632-5246

**D205-541-044**  
**Job Sheet 191324**



**Part No:** D205-541-044

**Job Qty:** 1 pcs

**Part Name:** Bell Medium Heli-Utility-Basket™ - RH



**Part Weight:** 0 lbs

**Status:** New

**Priority:** Medium

**Job Created:** 2/27/19

**Job Tracking No:**

**Due Date:** 3/19/19

**Created By:** Marie Lajeunesse

**Type:** Stock

**Description:** *order 13978*

**Note:** DWG DS19667 REV A, IIN D205-541 REV J SHEETS 29-31 IPP Rev:C Re-Format 02-08-30 KJ IPP Rev:D chg to revG Ecn 1157 08-03-19 DD verified by: IPP REV:E 13.06.21 IIN-D205-541 REV.J DD VERF:JFS IPP REV:F 15.02.02 AS PER DIS9667 DD VERF:JLM

**Ship Via:**

### Bill of Materials

### Job Routing

| Op No | Operation                      | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off                                 |
|-------|--------------------------------|-------|------------|----------|-----------|---------|-----------------------|-----------|------------------------------------------|
|       |                                |       |            |          | Setup Hrs | Run Hrs | Workcenter / Supplier | Lead Time |                                          |
| 110   | Small Fab - 1                  | 1 pcs | 3/19/19    | 0.00     | 1.18      |         | Small Fab - 1         |           | <i>DEB 19-03-25</i>                      |
|       |                                |       |            |          |           |         | Small Fab - 2         |           |                                          |
|       |                                |       |            |          |           |         | Small Fab - 3         |           |                                          |
|       |                                |       |            |          |           |         | Small Fab - 4         |           |                                          |
|       |                                |       |            |          |           |         | Small Fab - 5         |           |                                          |
|       |                                |       |            |          |           |         | Small Fab - 6         |           |                                          |
|       |                                |       |            |          |           |         | Small Fab - 7         |           |                                          |
| 120   | QC 5                           | 1 pcs | 3/19/19    | 0.00     | 0.00      |         | QC 5 - 10             |           | <i>MAR 25 2019</i><br><i>DAS 68 9-89</i> |
|       |                                |       |            |          |           |         | QC 5 - 12             |           |                                          |
|       |                                |       |            |          |           |         | QC 5 - 17             |           |                                          |
|       |                                |       |            |          |           |         | QC 5 - 18             |           |                                          |
|       |                                |       |            |          |           |         | QC 5 - 19             |           |                                          |
|       |                                |       |            |          |           |         | QC 5 - 22             |           |                                          |
|       |                                |       |            |          |           |         | QC 5 - 24             |           |                                          |
|       |                                |       |            |          |           |         | QC 5 - 3              |           |                                          |
|       |                                |       |            |          |           |         | QC 5 - 42             |           |                                          |
|       |                                |       |            |          |           |         | QC 5 - 43             |           |                                          |
|       |                                |       |            |          |           |         | QC 5 - 49             |           |                                          |
|       |                                |       |            |          |           |         | QC 5 - 51             |           |                                          |
|       |                                |       |            |          |           |         | QC 5 - 58             |           |                                          |
|       |                                |       |            |          |           |         | QC 5 - 68             |           |                                          |
|       |                                |       |            |          |           |         | QC 5 - 9              |           |                                          |
|       |                                |       |            |          |           |         | QC 5 - 50             |           |                                          |
|       |                                |       |            |          |           |         | QC 5 - 30             |           |                                          |
| 130   | Packaging 1-1 - Pick Kit - B4B | 1 pcs | 3/19/19    | 0.00     | 0.00      |         | Packaging 1 - 1 - B4B |           | <i>MAR 25 2019</i>                       |
|       |                                |       |            |          |           |         | Packaging 1 - 2 - B4B |           |                                          |
|       |                                |       |            |          |           |         | Packaging 1 - 3 - B4B |           |                                          |
|       |                                |       |            |          |           |         | Packaging 1 - 4 - B4B |           |                                          |
|       |                                |       |            |          |           |         | Packaging 1 - 5 - B4B |           |                                          |
|       |                                |       |            |          |           |         | Packaging 1 - 6 - B4B |           |                                          |

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|                                 |       |         |           |                        |  |
|---------------------------------|-------|---------|-----------|------------------------|--|
|                                 |       |         |           | Packaging 1 - 7 - B4B  |  |
|                                 |       |         |           | Packaging 1 - 8 - B4B  |  |
|                                 |       |         |           | Packaging 1 - 9 - B4B  |  |
|                                 |       |         |           | Packaging 1 - 10 - B4B |  |
|                                 |       |         |           | Packaging 1 - 11 - B4B |  |
|                                 |       |         |           | Packaging 1 - 12 - B4B |  |
|                                 |       |         |           | Packaging 1 - 13 - B4B |  |
|                                 |       |         |           | Packaging 1 - 14 - B4B |  |
|                                 |       |         |           | Packaging 1 - 15 - B4B |  |
|                                 |       |         |           | Packaging 1 - 16 - B4B |  |
|                                 |       |         |           | Packaging 1 - 17 - B4B |  |
|                                 |       |         |           | Packaging 1 - 18 - B4B |  |
|                                 |       |         |           | Packaging 1 - 19 - B4B |  |
|                                 |       |         |           | Packaging 1 - 20 - B4B |  |
|                                 |       |         |           | Packaging 1 - 21 - B4B |  |
|                                 |       |         |           | Packaging 1 - 22 - B4B |  |
|                                 |       |         |           | Packaging 1 - 23 - B4B |  |
|                                 |       |         |           | Packaging 1 - 24 - B4B |  |
|                                 |       |         |           | Packaging 1 - 25 - B4B |  |
|                                 |       |         |           | Packaging 1 - 26 - B4B |  |
|                                 |       |         |           | Packaging 1 - 27 - B4B |  |
|                                 |       |         |           | Packaging 1 - 28 - B4B |  |
|                                 |       |         |           | Packaging 1 - 29 - B4B |  |
|                                 |       |         |           | Packaging 1 - 30 - B4B |  |
|                                 |       |         |           | Packaging 1 - 31 - B4B |  |
|                                 |       |         |           | Packaging 1 - 32 - B4B |  |
|                                 |       |         |           | Packaging 1 - 33 - B4B |  |
|                                 |       |         |           | Packaging 1 - 34 - B4B |  |
|                                 |       |         |           | Packaging 1 - 35 - B4B |  |
| 140 QC 4                        | 1 pcs | 3/19/19 | 0.00 0.00 | QC 4 - 26              |  |
|                                 |       |         |           | QC 4 - 28              |  |
|                                 |       |         |           | QC 4 - 42              |  |
|                                 |       |         |           | QC 4 - 58              |  |
|                                 |       |         |           | QC 4 - 6               |  |
|                                 |       |         |           | QC 4 - 69              |  |
|                                 |       |         |           | QC 4 - 9               |  |
|                                 |       |         |           | QC 4 - 46              |  |
| 145 DC - 1 - B4B                | 1 pcs | 3/19/19 | 0.00 0.00 | DC - 1 - B4B           |  |
|                                 |       |         |           | DC - 2 - B4B           |  |
| 150 Packaging 3-1 - Stock - B4B | 1 pcs | 3/19/19 | 0.00 0.00 | Packaging 3 - 1 - B4B  |  |
|                                 |       |         |           | Packaging 3 - 2 - B4B  |  |
|                                 |       |         |           | Packaging 3 - 3 - B4B  |  |
|                                 |       |         |           | Packaging 3 - 4 - B4B  |  |
|                                 |       |         |           | Packaging 3 - 5 - B4B  |  |
|                                 |       |         |           | Packaging 3 - 6 - B4B  |  |
|                                 |       |         |           | Packaging 3 - 7 - B4B  |  |
|                                 |       |         |           | Packaging 3 - 8 - B4B  |  |
|                                 |       |         |           | Packaging 3 - 9 - B4B  |  |
|                                 |       |         |           | Packaging 3 - 10 - B4B |  |
|                                 |       |         |           | Packaging 3 - 11 - B4B |  |
|                                 |       |         |           | Packaging 3 - 12 - B4B |  |
|                                 |       |         |           | Packaging 3 - 13 - B4B |  |
|                                 |       |         |           | Packaging 3 - 14 - B4B |  |
|                                 |       |         |           | Packaging 3 - 15 - B4B |  |
|                                 |       |         |           | Packaging 3 - 16 - B4B |  |
|                                 |       |         |           | Packaging 3 - 17 - B4B |  |
|                                 |       |         |           | Packaging 3 - 18 - B4B |  |
|                                 |       |         |           | Packaging 3 - 19 - B4B |  |
|                                 |       |         |           | Packaging 3 - 20 - B4B |  |

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|     |            |       |         |                        |                 |
|-----|------------|-------|---------|------------------------|-----------------|
|     |            |       |         | Packaging 3 - 21 - B4B |                 |
|     |            |       |         | Packaging 3 - 22 - B4B |                 |
|     |            |       |         | Packaging 3 - 23 - B4B |                 |
|     |            |       |         | Packaging 3 - 24 - B4B |                 |
|     |            |       |         | Packaging 3 - 25 - B4B |                 |
|     |            |       |         | Packaging 3 - 26 - B4B |                 |
|     |            |       |         | Packaging 3 - 27 - B4B |                 |
|     |            |       |         | Packaging 3 - 28 - B4B |                 |
|     |            |       |         | Packaging 3 - 29 - B4B |                 |
|     |            |       |         | Packaging 3 - 30 - B4B |                 |
|     |            |       |         | Packaging 3 - 31 - B4B |                 |
|     |            |       |         | Packaging 3 - 32 - B4B |                 |
|     |            |       |         | Packaging 3 - 33 - B4B |                 |
|     |            |       |         | Packaging 3 - 34 - B4B |                 |
|     |            |       |         | Packaging 3 - 35 - B4B |                 |
| 160 | QC 21 - FG | 1 pcs | 3/19/19 | 0.00 0.00              | QC 21 - FG - 21 |
|     |            |       |         |                        | QC 21 - FG - 70 |
|     |            |       |         |                        | QC 21 - SA - 53 |
|     |            |       |         |                        | DAS             |
|     |            |       |         |                        | MAR 25 2019 70  |
|     |            |       |         |                        | 9-89            |

Part Op **110** - (Small Fab) Assemble as per Dwg.

Descriptions: **120** - (QC5- Inspect part completeness to step on W/O)

**130** - (Pick Kit)

**140** - (QC4- 100% Inspect kits for completeness)

**145** - (Document Control) Photocopy bluefile & type labels per PPPD205-541-044 CHG003

**150** - (Identify as per dwg & Stock Location: \_\_\_\_\_) Identify and pack for shipping as per PPP D205-541-044 Location: \_\_\_\_\_

**160** - (QC21- Final Inspection - Work Order Release)



M. U. 008809

## Job BOM

| Part / Item   | Component Name           | Quantity      | Operation                          | Container |
|---------------|--------------------------|---------------|------------------------------------|-----------|
| AN3-16A       | Bolt                     | 2 Ea (2 ea)   | 110-Small Fab - 1                  | 5149258-1 |
| AN4-22A       | Bolt                     | 1 Ea (1 ea)   | 110-Small Fab - 1                  | 5097470   |
| AN4-24A       | Bolt                     | 1 Ea (1 ea)   | 110-Small Fab - 1                  | 5130326   |
| AN4-7A        | Bolt                     | 2 Ea (2 ea)   | 110-Small Fab - 1                  | 5107746   |
| AN5-17A       | Bolt                     | 4 Ea (4 ea)   | 110-Small Fab - 1                  | 5149141-8 |
| AN970-4       | Washer                   | 4 Ea (4 ea)   | 110-Small Fab - 1                  | 5114901-1 |
| D2022-101     | Spacer                   | 2 pcs (2 ea)  | 110-Small Fab - 1                  | 5151697   |
| D2258-300     | Placard                  | 1 pcs (1 ea)  | 110-Small Fab - 1                  | 5152267   |
| D2332-041     | Lid Prop Assembly 6.69"  | 1 pcs (1 ea)  | 110-Small Fab - 1                  | 5144996   |
| D2512         | Basket Lid               | 1 pcs (1 ea)  | 110-Small Fab - 1                  | 5164302   |
| D2530         | Handle Weldment          | 1 pcs (1 ea)  | 110-Small Fab - 1                  | 5155648   |
| D2535         | Spring                   | 2 pcs (2 ea)  | 110-Small Fab - 1                  | 5154034   |
| D2537-20      | Bushing                  | 2 pcs (2 ea)  | 110-Small Fab - 1                  | 5123161   |
| D2931         | Bumper                   | 2 pcs (2 ea)  | 110-Small Fab - 1                  | F86435    |
| D3053-042     | 212 Basket Base Assembly | 1 pcs (1 ea)  | 110-Small Fab - 1                  | 5163540   |
| MS20600-AD4W3 | Cherry Rivet             | 2 Ea (2 ea)   | 110-Small Fab - 1                  | 5076007   |
| MS21042L3     | Nut                      | 2 Ea (2 ea)   | 110-Small Fab - 1                  | 5157462-1 |
| MS21042L4     | Nut                      | 4 Ea (4 ea)   | 110-Small Fab - 1                  | 5078254   |
| MS21042L5     | Nut                      | 4 Ea (4 ea)   | 110-Small Fab - 1                  | 5149145-1 |
| NAS1149D0416J | Washer                   | 2 Ea (2 ea)   | 110-Small Fab - 1                  | FM131511  |
| NAS1149D0463J | Washer                   | 2 Ea (2 ea)   | 110-Small Fab - 1                  | 5055952   |
| NAS1149D0563J | Washer                   | 4 Ea (4 ea)   | 110-Small Fab - 1                  | 5068662-1 |
| NAS1149DN832J | Washer                   | 2 Ea (2 ea)   | 110-Small Fab - 1                  | 5034411-1 |
| AN4-12A       | Bolt                     | 3 Ea (3 ea)   | 130-Packaging 1-1 - Pick Kit - B4B | 5109960   |
| AN4-13A       | Bolt                     | 9 Ea (9 ea)   | 130-Packaging 1-1 - Pick Kit - B4B | 5158578   |
| AN4-14A       | Bolt                     | 2 Ea (2 ea)   | 130-Packaging 1-1 - Pick Kit - B4B | 5114891   |
| AN4-7A        | Bolt                     | 2 Ea (2 ea)   | 130-Packaging 1-1 - Pick Kit - B4B | 5107746   |
| AN5-13A       | Bolt                     | 1 Ea (1 ea)   | 130-Packaging 1-1 - Pick Kit - B4B | 5054115   |
| AN5-7A        | Bolt                     | 1 Ea (1 ea)   | 130-Packaging 1-1 - Pick Kit - B4B | FM123355  |
| D2199-1       | Struts, 19"              | 1 pcs (1 ea)  | 130-Packaging 1-1 - Pick Kit - B4B | 5153205   |
| D2199-23      | Strut                    | 1 pcs (1 ea)  | 130-Packaging 1-1 - Pick Kit - B4B | 5153087   |
| D2199-25      | Strut                    | 1 pcs (1 ea)  | 130-Packaging 1-1 - Pick Kit - B4B | 5153126   |
| D2498         | Mounting Lug             | 1 pcs (1 ea)  | 130-Packaging 1-1 - Pick Kit - B4B | 5156399   |
| D2499         | Mounting Bracket         | 1 pcs (1 ea)  | 130-Packaging 1-1 - Pick Kit - B4B | 5003322   |
| D2515         | Bushing                  | 2 pcs (2 ea)  | 130-Packaging 1-1 - Pick Kit - B4B | F160407   |
| D3052-1       | Mounting Lug             | 1 pcs (1 ea)  | 130-Packaging 1-1 - Pick Kit - B4B | 5155960   |
| MS21042L4     | Nut                      | 16 Ea (16 ea) | 130-Packaging 1-1 - Pick Kit - B4B | 5149814   |
| MS21042L5     | Nut                      | 2 Ea (2 ea)   | 130-Packaging 1-1 - Pick Kit - B4B | 5149145   |
| NAS1149D0432J | Washer                   | 4 Ea (4 ea)   | 130-Packaging 1-1 - Pick Kit - B4B | 5093256   |
| NAS1149D0463J | Washer                   | 33 Ea (33 ea) | 130-Packaging 1-1 - Pick Kit - B4B | 5157445   |
| NAS1149D0532J | Washer                   | 2 Ea (2 ea)   | 130-Packaging 1-1 - Pick Kit - B4B | FM131467  |
| NAS1149D0563J | Washer                   | 5 Ea (5 ea)   | 130-Packaging 1-1 - Pick Kit - B4B | 5156086   |

| Job Allocations                    |                |          |           |           |
|------------------------------------|----------------|----------|-----------|-----------|
| Operation                          | Component Part | Required | Inventory | Allocated |
| 110-Small Fab - 1                  | AN3-16A        | 2        | 57        | 0         |
|                                    | AN4-22A        | 1        | 111       | 0         |
|                                    | AN4-24A        | 1        | 38        | 0         |
|                                    | AN4-7A         | 2        | 132       | 0         |
|                                    | AN5-17A        | 4        | 239       | 0         |
|                                    | AN970-4        | 4        | 76        | 0         |
|                                    | D2022-101      | 2        | 23        | 0         |
|                                    | D2258-300      | 1        | 14        | 0         |
|                                    | D2332-041      | 1        | 4         | 0         |
|                                    | D2512          | 1        | 0         | 0         |
|                                    | D2530          | 1        | 15        | 0         |
|                                    | D2535          | 2        | 311       | 0         |
|                                    | D2537          | 2        | 118       | 0         |
|                                    | D2931          | 2        | 789       | 0         |
|                                    | D3053-042      | 1        | 0         | 0         |
|                                    | MS20600-AD4W3  | 2        | 709       | 0         |
|                                    | MS21042L3      | 2        | 2,214     | 0         |
|                                    | MS21042L4      | 4        | 2,205     | 0         |
|                                    | MS21042L5      | 4        | 759       | 0         |
|                                    | NAS1149D0416J  | 2        | 2,094     | 0         |
|                                    | NAS1149D0463J  | 2        | 3,158     | 0         |
|                                    | NAS1149D0563J  | 4        | 1,808     | 0         |
|                                    | NAS1149DN832J  | 2        | 1,043     | 0         |
| 130-Packaging 1-1 - Pick Kit - B4B | AN4-12A        | 3        | 174       | 0         |
|                                    | AN4-13A        | 9        | 1,113     | 0         |
|                                    | AN4-14A        | 2        | 348       | 0         |
|                                    | AN4-7A         | 2        | 132       | 0         |
|                                    | AN5-13A        | 1        | 87        | 0         |
|                                    | AN5-7A         | 1        | 3,157     | 0         |
|                                    | D2199-1        | 1        | 6         | 0         |
|                                    | D2199-23       | 1        | 5         | 0         |
|                                    | D2199-25       | 1        | 5         | 0         |
|                                    | D2498          | 1        | 8         | 0         |
|                                    | D2499          | 1        | 9         | 0         |
|                                    | D2515          | 2        | 76        | 0         |
|                                    | D3052-1        | 1        | 6         | 0         |
|                                    | MS21042L4      | 16       | 2,205     | 0         |
|                                    | MS21042L5      | 2        | 759       | 0         |
|                                    | NAS1149D0432J  | 4        | 475       | 0         |
|                                    | NAS1149D0463J  | 33       | 3,158     | 0         |
|                                    | NAS1149D0532J  | 2        | 147       | 0         |
|                                    | NAS1149D0563J  | 5        | 1,808     | 0         |
| Part Specifications                |                |          |           |           |
| Specifications could not be found. |                |          |           |           |

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Entered: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. \_\_\_\_\_

Route update only ☐

|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |                        |  |
|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|------------------------|--|
| Job: _____<br><br>Part No. _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/> | <b>DEPARTMENT/PROCESS</b><br><br><div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/><br/>           Machining <input type="checkbox"/><br/>           Large Fab <input type="checkbox"/> </div> <div>           Cross tube <input type="checkbox"/><br/>           Small Fab <input type="checkbox"/><br/>           Finishing <input type="checkbox"/> </div> <div>           Eng. (Non-AW) <input type="checkbox"/><br/>           Prod. Eng. Coord. <input type="checkbox"/><br/>           Rec/Store/Packaging <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/><br/>           Water Jet <input type="checkbox"/><br/>           Supplier <input type="checkbox"/><br/>           Quality <input type="checkbox"/> </div> </div>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |  |                        |  |
| Date :                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 | Sequence #:                                                                                                                       | QTY Affected :                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |  | MRB (QSI042)           |  |
| Description Work Order Deviation                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |                                                                                                                                   | Disposition                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |  | Completed By           |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  | Lead hand / Supervisor |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |                        |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |                        |  |
| <b>Root Cause</b><br><br><div style="display: flex; flex-direction: column;"> <div>Operator <input type="checkbox"/></div> <div>Manufacturing Process <input type="checkbox"/></div> <div>Equip/Tooling <input type="checkbox"/></div> <div>Handling/Preservation <input type="checkbox"/></div> <div>Material <input type="checkbox"/></div> <div>Product Improvement <input type="checkbox"/></div> <div>Process Improvement <input type="checkbox"/></div> <div>Human Factors <input type="checkbox"/></div> </div> |                                                                                                                                   | <b>FAULT CATEGORY</b><br><br><div style="display: flex; flex-wrap: wrap;"> <div style="width: 50%;"> <input type="checkbox"/> Pressure/Forced<br/> <input type="checkbox"/> Bending<br/> <input type="checkbox"/> Crushing<br/> <input type="checkbox"/> Cracks<br/> <input type="checkbox"/> Crimp/Kink/Ripple/Wave/Twist<br/> <input type="checkbox"/> Marks/Chatter<br/> <input type="checkbox"/> Mislabeled         </div> <div style="width: 50%;"> <input type="checkbox"/> Contamination<br/> <input type="checkbox"/> Misaligned/off center<br/> <input type="checkbox"/> BOM/Route<br/> <input type="checkbox"/> Broken/Damage/Defect<br/> <input type="checkbox"/> Incomplete/Unclear Instructions<br/> <input type="checkbox"/> Drill Holes<br/> <input type="checkbox"/> Fit/Function         </div> <div style="width: 50%;"> <input type="checkbox"/> Power Loss/Surge<br/> <input type="checkbox"/> Folio/Program<br/> <input type="checkbox"/> Grain Direction<br/> <input type="checkbox"/> Weld<br/> <input type="checkbox"/> Wrong Stock Pulled<br/> <input type="checkbox"/> Out of Sequence<br/> <input type="checkbox"/> Off-set/Set-up         </div> <div style="width: 50%;"> <input type="checkbox"/> Positioned Wrong<br/> <input type="checkbox"/> Outside Tolerance<br/> <input type="checkbox"/> Drawing<br/> <input type="checkbox"/> Finish<br/> <input type="checkbox"/> Part Lost/Missing<br/> <input type="checkbox"/> Misread         </div> </div> |  |                        |  |
| Other/Details: _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |                        |  |

**DART**  
AEROSPACE

1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
CANADA  
TEL.: 1 813 632-5200  
Email: sales@dartaero.com  
www.dartaerospace.com

Container No: S165215



Part: D205-541-044

Job No: 191324

Serial No/Batch: S165215

Revision:

Inspector:

Exp Date:

Instructions: TC STC SH96-120 Issue 2, FAA STC SR00696

| Qty<br>-043 | Qty<br>-044 | Qty<br>-045 | Qty<br>-046 | Qty<br>-141 | Qty<br>-142 | Part<br>Number | Description                  |
|-------------|-------------|-------------|-------------|-------------|-------------|----------------|------------------------------|
| 2           | 2           | 2           | 2           |             |             | D2515          | BUSHING                      |
| 1*          | 1*          | 1*          | 1*          |             |             | D2530          | HANDLE ASSEMBLY              |
| 2*          | 2*          | 2*          | 2*          |             |             | D2535          | SPRING                       |
| 2*          | 2*          | 2*          | 2*          |             |             | D2537          | BUSHING                      |
| 2*          | 2*          |             |             |             |             | D2931          | BUMPER                       |
| 1           | 1           | 1           | 1           |             |             | D3052-1        | MOUNTING LUG                 |
| 1*          |             |             |             |             |             | D3053-041      | BASKET BASE ASSEMBLY, LH     |
|             | 1*          |             |             |             |             | D3053-042      | BASKET BASE ASSEMBLY, RH     |
|             |             | 1*          |             |             |             | D3712-041      | BASKET BASE                  |
|             |             |             | 1*          |             |             | D3712-042      | BASKET BASE                  |
|             |             | 1*          |             |             |             | D3713-041      | LID ASSEMBLY                 |
|             |             |             | 1*          |             |             | D3713-042      | LID ASSEMBLY                 |
|             |             | 6*          | 6*          |             |             | D3723-1        | BUSHING                      |
|             |             |             |             | 2           | 2           | D3953-9        | GAS SPRING SPACER (OPTIONAL) |
|             |             |             |             | 1           |             | D4041-011      | SHORT BASKET ASS'Y, LH       |
|             |             |             |             |             | 1           | D4041-012      | SHORT BASKET ASS'Y, RH       |
|             |             |             |             | 1           |             | D4048-041      | MOUNTING LUG ASS'Y           |
|             |             |             |             |             | 1           | D4048-042      | MOUNTING LUG ASS'Y           |
|             |             |             |             | 1           |             | D4048-5        | MOUNTING LUG                 |
|             |             |             |             |             | 1           | D4048-6        | MOUNTING LUG                 |
|             |             |             |             | 1           |             | D4048-7        | MOUNTING LUG                 |
|             |             |             |             |             | 1           | D4048-8        | MOUNTING LUG                 |
|             |             |             |             | 6           | 6           | D4048-9        | BUSHING                      |
|             |             |             |             | 1           |             | D4049-041      | MOUNTING LUG ASS'Y           |
|             |             |             |             |             | 1           | D4049-042      | MOUNTING LUG ASS'Y           |
|             |             |             |             | 1           |             | D4049-5        | MOUNTING LUG                 |
|             |             |             |             |             | 1           | D4049-8        | MOUNTING LUG                 |
|             |             |             |             | 1           | 1           | D4050-1        | STRUT                        |
|             |             |             |             | 1           | 1           | D4050-3        | STRUT                        |
|             |             |             |             | 1           |             | D4050-5        | STRUT                        |
|             |             |             |             |             | 1           | D4050-8        | STRUT                        |
|             |             |             |             | 1           |             | D4051-041      | GUARD (OPTIONAL)             |
|             |             |             |             |             | 1           | D4051-042      | GUARD (OPTIONAL)             |
|             |             |             |             | 2           | 2           | D4052-1        | EYE BOLT                     |
|             |             |             |             | 10          | 10          | AN3-5A         | BOLT                         |
|             |             |             |             | 1           | 1           | AN3-7A         | BOLT (OPTIONAL)              |
|             |             |             |             | 4           | 4           | AN3-11A        | BOLT (OPTIONAL)              |
| 2*          | 2*          | 2*          | 2*          |             |             | AN3-16A        | BOLT                         |
|             |             |             |             | 5           | 5           | AN4-6A         | BOLT                         |
| 2*          | 2*          |             |             |             |             | AN4-7A         | BOLT                         |
| 2           | 2           | 2           | 2           | 1           | 1           | AN4-7A         | BOLT                         |
| 3           | 3           | 3           | 3           | 2           | 2           | AN4-12A        | BOLT                         |
| 9           | 9           | 9           | 9           |             |             | AN4-13A        | BOLT                         |
| 2           | 2           | 2           | 2           | 11          | 11          | AN4-14A        | BOLT                         |
|             |             |             |             | 1           | 1           | AN4-16A        | BOLT                         |
|             |             | 3*          | 3*          |             |             | AN4-20A        | BOLT                         |



# DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D205-541 REV. J AND  
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D205-541 REV. 4

REF TCCA STC: SH96-120

REF FAA STC: SR00696NY

REF EASA STC: EASA.IM.R.S.01242

## PURPOSE:

FOR CUSTOMERS/OPERATORS CONCERNED WITH GAPS AT STA's 84.29, 129.00 AND 155.06 WHILE INSTALLING D205-541-043/-044/-045/-046 BASKETS, IT IS ACCEPTABLE TO FILL THE GAPS WITH WASHERS TO REDUCE UNNECESSARY STRESS ON THE MOUNTING LUGS.

## CHANGE:

INSTALL THE D205-541-043/-044/-045/-046 BASKET KITS PER INSTALLATION INSTRUCTIONS D205-541 WITH ADDITIONAL WASHERS AS SHOWN IN FIGURE 1 OF THIS SERVICE INSTRUCTION.

## PARTS LIST:

THE PARTS LISTS FOR D205-541-043/-044 AT CHG 003 OR LATER AND D205-541-045/-046 AT CHG 002 OR LATER ARE AMENDED AS FOLLOWS:

### 25.8 D205-541 INSTALLATION PARTS LIST (ICA-D205-541)

### 5.2 D205-541-043 INSTALLATION PARTS LIST (D205-541)

| QTY<br>-043 | QTY<br>-044 | QTY<br>-045 | QTY<br>-046 | PART NUMBER  | DESCRIPTION            |
|-------------|-------------|-------------|-------------|--------------|------------------------|
| X           |             |             |             | D205-541-043 | HELI-UTILITY-BASKET-LH |
|             | X           |             |             | D205-541-044 | HELI-UTILITY-BASKET-RH |
|             |             | X           |             | D205-541-045 | HELI-UTILITY-BASKET-LH |
|             |             |             | X           | D205-541-046 | HELI-UTILITY-BASKET-RH |

## ADD:

|   |   |   |   |               |        |
|---|---|---|---|---------------|--------|
| 4 | 4 | 4 | 4 | NAS1149D0463J | WASHER |
| 4 | 4 | 4 | 4 | NAS1149D0432J | WASHER |
| 2 | 2 | 2 | 2 | NAS1149D0532J | WASHER |
| 2 | 2 | 2 | 2 | NAS1149D0563J | WASHER |

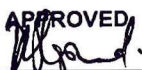
## WEIGHT AND BALANCE:

THERE IS NEGLIGIBLE WEIGHT CHANGE ASSOCIATED WITH THIS MODIFICATION.

## MAINTENANCE:

PER ICA-D205-541.

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED  
BY:   
D. SHEPHERD (DE # 02)  
DATE: 14.11.27  
CERT. NO.: SH96-120  
ISSUE NO.: 3

|            |                                                                                     |                                                                                                                                                                                                                                                                          |              |
|------------|-------------------------------------------------------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| A          | NEW ISSUE                                                                           | DW                                                                                                                                                                                                                                                                       | 14.11.27     |
| REV.       | DESCRIPTION                                                                         | BY                                                                                                                                                                                                                                                                       | DATE         |
| DESIGN     | DW                                                                                  | <b>DART AEROSPACE LTD</b>                                                                                                                                                                                                                                                |              |
| DRAWN      | DW                                                                                  | HAWKESBURY, ONTARIO, CANADA                                                                                                                                                                                                                                              |              |
| CHECKED    | AP                                                                                  | DRAWING NO.                                                                                                                                                                                                                                                              | REV. A       |
| MFG. APPR. | N/A                                                                                 | DSI 9667                                                                                                                                                                                                                                                                 | SHEET 1 OF 2 |
| APPROVED   |  | TITLE                                                                                                                                                                                                                                                                    | SCALE        |
| DE APPR.   |                                                                                     | WASHER ADDITION                                                                                                                                                                                                                                                          | NTS          |
| DATE       | 14.11.27                                                                            | COPYRIGHT © 2014 BY DART AEROSPACE LTD<br>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. |              |

| Qty<br>-043 | Qty<br>-044 | Qty<br>-045 | Qty<br>-046 | Qty<br>-141 | Qty<br>-142 | Part Number  | Description                             |
|-------------|-------------|-------------|-------------|-------------|-------------|--------------|-----------------------------------------|
| 1*          | 1*          | 1*          | 1*          |             |             | AN4-22A      | BOLT                                    |
| 1*          | 1*          | 1*          | 1*          |             |             | AN4-24A      | BOLT                                    |
| 1           | 1           | 1           | 1           |             |             | AN5-7A       | BOLT                                    |
| 1           | 1           | 1           | 1           |             |             | AN5-13A      | BOLT                                    |
| 4*          | 4*          | 4*          | 4*          |             |             | AN5-17A      | BOLT                                    |
|             |             |             |             | 5           | 5           | AN960-10     | WASHER (OR NAS1149F0363P)<br>(OPTIONAL) |
|             |             |             |             | 20          | 20          | AN960JD10L   | WASHER (OR NAS1149D0332J)               |
| 2*          | 2*          | 6*          | 6*          |             |             | AN960JD416   | WASHER (OR NAS1149D0463J)               |
|             |             |             |             | 2           | 2           | AN960-416    | WASHER (OR NAS1149F0463P)<br>(OPTIONAL) |
| 27          | 27          | 27          | 27          | 36          | 36          | AN960JD416   | WASHER (OR NAS1149D0463J)               |
| 2*          | 2*          | 2*          | 2*          | 4           | 4           | AN960JD416L  | WASHER (OR NAS1149D0416J)               |
| 4*          | 4*          | 4*          | 4*          |             |             | AN960JD516   | WASHER (OR NAS1149D0563J)               |
| 3           | 3           | 3           | 3           |             |             | AN960JD516   | WASHER (OR NAS1149D0563J)               |
| 2           | 2           |             |             |             |             | AN960JD8     | WASHER (OR NAS1149DN832J)               |
| 4*          | 4*          | 4*          | 4*          |             |             | AN970-4      | WASHER                                  |
| 2*          | 2*          |             |             |             |             | MS20600AD4W3 | RIVET                                   |
| 2*          | 2*          | 2*          | 2*          | 8           | 8           | MS21042L3    | NUT (OR MS21042-3)                      |
|             |             |             |             | 5           | 5           | MS21042L3    | NUT (OR MS21042-3) (OPTIONAL)           |
| 4*          | 4*          | 5*          | 5*          |             |             | MS21042L4    | NUT (OR MS21042-4)                      |
| 16          | 16          | 16          | 16          | 20          | 20          | MS21042L4    | NUT (OR MS21042-4)                      |
|             |             |             |             | 2           | 2           | MS21043L4    | NUT (OR MS21043-4)                      |
| 4*          | 4*          | 4*          | 4*          |             |             | MS21042L5    | NUT (OR MS21042-5)                      |
| 2           | 2           | 2           | 2           |             |             | MS21042L5    | NUT (OR MS21042-5)                      |

\* = ASSEMBLED AT DART

## 6.0 PARTS LIST HELI-ACCESS-STEP™

| Qty<br>-047 | Qty<br>-048 | Part Number  | Description          |
|-------------|-------------|--------------|----------------------|
| X           |             | D205-541-047 | HELI-ACCESS-STEP, LH |
|             | X           | D205-541-048 | HELI-ACCESS-STEP, RH |
|             |             |              |                      |
| 1           |             | D3724-041    | STEP ASSY, LH        |
|             | 1           | D3724-042    | STEP ASSY, RH        |
| 2           | 2           | D3731-1      | PLATE                |
| 2           | 2           | D3751-1      | SHIM                 |
| 6           | 6           | AN4-13A      | BOLT                 |
| 6           | 6           | AN4-14A      | BOLT                 |
| 24          | 24          | AN960JD416   | WASHER               |
| 12          | 12          | MS21042L4    | NUT (OR MS21042-4)   |

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Revision: J

Date: 10.03.08



## 4.0 WEIGHT AND BALANCE

| Installation                                | Weight            | LATERAL                |                             | LONGITUDINAL        |                               |
|---------------------------------------------|-------------------|------------------------|-----------------------------|---------------------|-------------------------------|
|                                             |                   | Arm                    | Moment                      | Arm                 | Moment                        |
| D205-541-043<br><i>Heli-Utility-Basket™</i> | 118 lb<br>53.6 kg | - 63.13 in<br>- 1.60 m | - 7449 in-lb<br>- 85.8 m-kg | 132.25 in<br>3.36 m | 15606 in-lb<br>180.1 m-kg     |
| D205-541-044<br><i>Heli-Utility-Basket™</i> | 118 lb<br>53.6 kg | + 63.13 in<br>+ 1.60 m | + 7449 in-lb<br>+ 85.8 m-kg | 132.25 in<br>3.36 m | 15606 in-lb<br>180.1 m-kg     |
| D205-541-045<br><i>Heli-Utility-Basket™</i> | 104 lb<br>47.3 kg | - 63.13 in<br>- 1.60 m | - 6566 in-lb<br>- 75.7 m-kg | 132.25 in<br>3.36 m | 13754 in-lb<br>158.9 m-kg     |
| D205-541-046<br><i>Heli-Utility-Basket™</i> | 104 lb<br>47.3 kg | + 63.13 in<br>+ 1.60 m | + 6566 in-lb<br>+ 75.7 m-kg | 132.25 in<br>3.36 m | 13754 in-lb<br>158.9 m-kg     |
| D205-541-047<br><i>Heli-Access-Step™</i>    | 14 lb<br>6.4 kg   | - 76.11 in<br>- 1.93 m | - 1066 in-lb<br>- 12.4 m-kg | 126.56 in<br>3.21 m | + 1772 in-lb<br>+ 20.5 m-kg   |
| D205-541-048<br><i>Heli-Access-Step™</i>    | 14 lb<br>6.4 kg   | + 76.11 in<br>+ 1.93 m | + 1066 in-lb<br>+ 12.4 m-kg | 126.56 in<br>3.21 m | + 1772 in-lb<br>+ 20.5 m-kg   |
| D205-541-141<br><i>Heli-Utility-Basket™</i> | 69 lb<br>31.4 kg  | - 59.9 in<br>- 1.5 m   | - 4133 in-lb<br>- 47.1 m-kg | 161.6 in<br>4.1 m   | + 11150 in-lb<br>+ 128.7 m-kg |
| D205-541-142<br><i>Heli-Utility-Basket™</i> | 69 lb<br>31.4 kg  | + 59.9 in<br>+ 1.5 m   | + 4133 in-lb<br>+ 47.1 m-kg | 161.6 in<br>4.1 m   | + 11150 in-lb<br>+ 128.7 m-kg |

## 5.0 PARTS LIST HELI-UTILITY-BASKET™

| Qty<br>-043 | Qty<br>-044 | Qty<br>-045 | Qty<br>-046 | Qty<br>-141 | Qty<br>-142 | Part<br>Number | Description                                             |
|-------------|-------------|-------------|-------------|-------------|-------------|----------------|---------------------------------------------------------|
| X           |             |             |             |             |             | D205-541-043   | HELI-UTILITY-BASKET, LH                                 |
|             | X           |             |             |             |             | D205-541-044   | HELI-UTILITY-BASKET, RH                                 |
|             |             | X           |             |             |             | D205-541-045   | HELI-UTILITY-BASKET, LH                                 |
|             |             |             | X           |             |             | D205-541-046   | HELI-UTILITY-BASKET, RH                                 |
|             |             |             |             | X           |             | D205-541-141   | HELI-UTILITY-BASKET, LH                                 |
|             |             |             |             |             | X           | D205-541-142   | HELI-UTILITY-BASKET, RH                                 |
|             |             |             |             | 1           | 1           | DSI 9302-011   | STRUT MODIFICATION KIT (FOR D205-633 STEP INSTALLATION) |
| 2*          | 2*          |             |             |             |             | D2022-101      | SPACER                                                  |
|             |             |             |             | 2           | 2           | D2022-101      | SPACER (FOR D205-633 STEP INSTALLATION)                 |
| 1           | 1           | 1           | 1           |             |             | D2199-1        | STRUT                                                   |
| 1           | 1           | 1           | 1           |             |             | D2199-23       | STRUT                                                   |
| 1           | 1           | 1           | 1           |             |             | D2199-25       | STRUT                                                   |
| 1*          | 1*          | 1*          | 1*          |             |             | D2258-300      | LABEL                                                   |
| 1*          | 1*          | 1*          | 1*          |             |             | D2332-041      | PROP ASSEMBLY                                           |
|             |             |             |             | 1           | 1           | D2332-041      | PROP ASSEMBLY (OPTIONAL)                                |
|             |             |             |             | 1           | 1           | D2464-0410     | NEOPRENE SEAL                                           |
| 1           | 1           | 1           | 1           |             |             | D2498          | MOUNTING LUG                                            |
| 1           | 1           | 1           | 1           |             |             | D2499          | MOUNTING LUG                                            |
| 1*          | 1*          |             |             |             |             | D2512          | BASKET LID ASSEMBLY                                     |

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Revision: J

Date: 10.03.08



## Change Record

PAGE 1 OF 1

Part Number: D205-541-043/-044

Description: HELI UTILITY BASKET, LH/RH

[illegible]